

# Work Order ID 65336



January 12, 2011 10:52:30 AM



*Rush*


Page 1

Item ID: D3953-7 Accept  Setup Start   
Revision ID:   
Item Name: Spring Spacer *M* Stop   
Start Date: 1/12/11 Start Qty: 2.00  Cust Item ID:   
Required Date: 1/12/11 Req'd Qty: 2.00  Customer:   
Reference:

Approvals: Process Plan: *MM* Date: 11-01-12 Tooling: Date:   
QC: Date: SPC (Y/N): Date:   
Run Start   
Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3953	C

100  0.00  
Hardinge *2 0*  
Hardinge CNC Lathe Small

Memo  
TURN AS PER FOLIO FA854 & DWG  
FOLIO REV: *C*  
DWG REV: *C*  
DEBURR

*SA 11/1/12*

110  0.00  
QC *2 0*  
Quality Control

QC2- Inspect parts off machine FAI/FAIB  
Memo  
0.00

*SA 11/1/12*

# Work Order ID 65336

January 12, 2011 10:52:30 AM



Page 2

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring Spacer

Start Date: 1/12/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/12/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*[Handwritten signature]*

3

Ø

130

Identify as per dwg & Stock Location: 51 103

0.00



Packaging

Memo

0.00

Packaging

*mmk 11-01-12*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/01/12 [Signature]*

*mmk 11-01-12*

# Picklist Print

January 12, 2011 10:52:29 AM

Page 1

Work Order ID: 65336

Parent Item: D3953-7

Parent Item Name: Spring Spacer



Start Date: 1/12/11

Required Date: 1/12/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELNR0.750

Purchased

No

100

f

87.8970

0.05

0.105263



Delrin Round Bar 0.75"



SA 11/1/12

Location

Loc Qty

Loc Code

MAT

37.35

116183

37.35

MAT050

50.547

112418

0.12

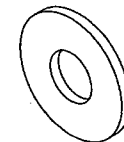
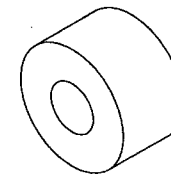
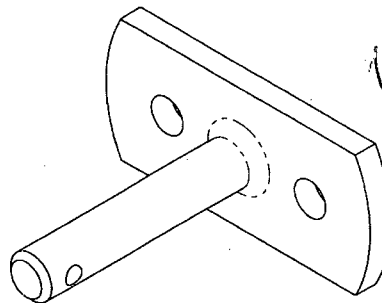
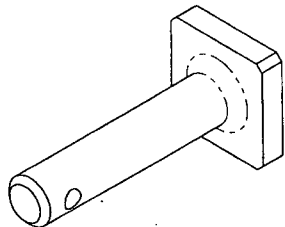
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50.427

1 St



8 7 6 5 4 3 2 1



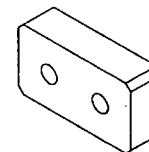
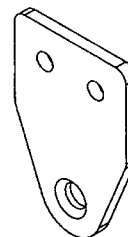
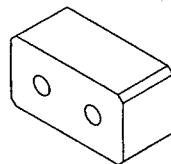
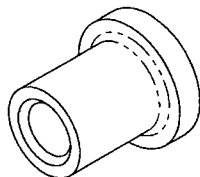
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



**RELEASED**  
2010-02-26

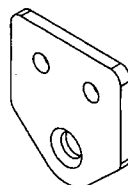
**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

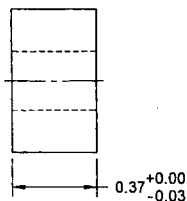
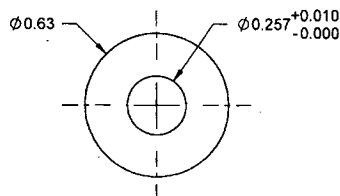
**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



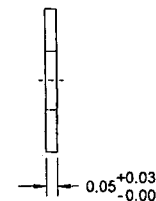
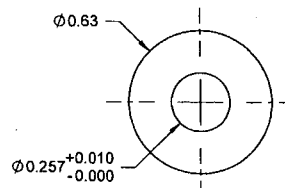
**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 18-4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); & SYMM WAS & SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

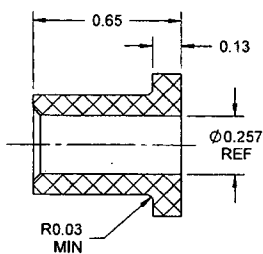
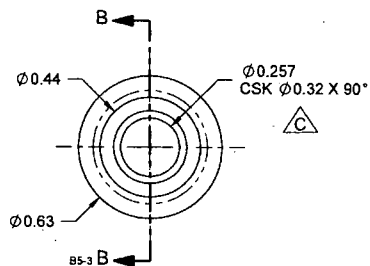
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**D3953-7 GAS SPRING SPACER**

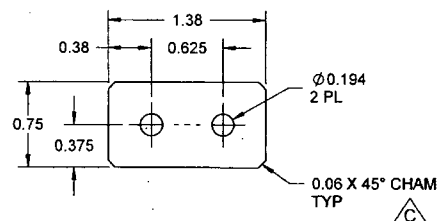


**D3953-9 GAS SPRING WASHER**



**SECTION B-B** 87-3

**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**

**NOTES:**

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH  
-13: 0.17 lbs

**RELEASED**  
2010-02-26

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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